

17-4 11900 34

Work Order ID 140000

140000

Page 1

December 16, 2015 11:57:14 AM

Item ID: E4715-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Stud

Start Date: 12/16/2015 Start Qty: 11.00

11

Cust Item ID:

Required Date: 3/1/2016 Req'd Qty: 11.00

11

Customer:

Reference:

Approvals:

Process Plan:

SL

Date:

20151217

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

E4715

REV PA2

A M

100

0.00

100

DOOSAN LATHE

Doosan

Memo

0.12

Doosan Lathe

1- Turn as per Folio

Rev: AA & Dwg D

Rev: B

3-Deburr per dwg

11

0

DAS

45

9-89

20163-4

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

11

0

DAS

45

9-89

20163-4

Work Order ID 140000

December 16, 2015 11:57:14 AM

140000

Page 2

Item ID: E4715-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Stud

Start Date: 12/16/2015 Start Qty: 11.00

11

Cust Item ID:

Required Date: 3/1/2016 Req'd Qty: 11.00

11

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC8- Inspect parts - second check	0.00				11	0		DAS 14 9-99 16/03/07
140									
QC	Memo	0.00							
Quality Control	100% CHECK,CHECK ALL DIMENSIONS AND THREAD FIT								
150	PURCHASING	0.00				11		MAR 15 2016	DAS 13 9-99
150									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: 311650								
	LPI Per ASTM 1417 LEVEL 2								
	Certificate of conformaty is required								
160	Receive & Inspect for Damage & Mat'l Certs	0.00				11 X	80	16-03-05	
160									
Packaging	Memo	0.00							
Packaging	Ensure certificate of conformity is attached								

Work Order ID 140000

December 16, 2015 11:57:14 AM

140000

Page 3

Item ID: E4715-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Stud
Start Date: 12/16/2015 Start Qty: 11.00 ***11*** Cust Item ID:
Required Date: 3/1/2016 Req'd Qty: 11.00 ***11*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-99
170									
QC	Memo	0.00							
Quality Control									MAR 15 2016
180	Identify as per dwg & Stock Location: <u>51167</u>	0.00							MAR 15 2016
180									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.02							
Quality Control									MAR 21 2016

MCS MAR 21 2016

Picklist Print

December 16, 2015 11:57:18 AM

Page 1

Work Order ID: 140000

140000

Parent Item: E4715-3

F4715-3

Parent Item Name: Stud

Start Date: 12/16/2015

Required Date: 3/1/2016

Start Qty: 11.00

Required Qty: 11.00

Comments: IPP REV:A NEW ISSUE 12-10-15 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174PH-H900R0.750		Purchased			No		f	41.0000		3.473684			

M174PH-H900R0 750

**

17-4 SS H900 ROUND BAR 0.750"

Location

Loc Qty

Loc Code

MAT031

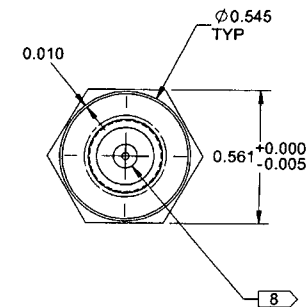
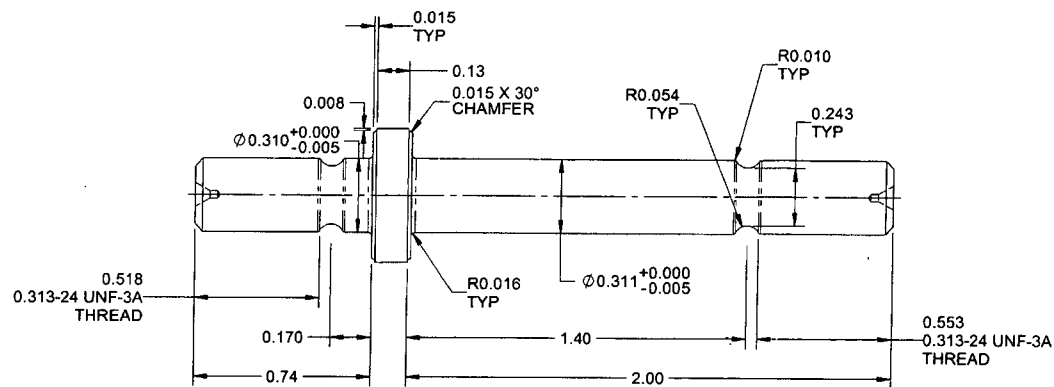
41

M129892

41

DAS

3,474 **45** 2016-3-4
9-89



E4715-3 STUD

NOTES:

- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 STAINLESS STEEL ROUND BAR, H900 CONDITION
PER AMS5643, OR ASTM A564
REF DART SPEC M17-4R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 0.068 lbs
- 8) CENTER DRILL MAY BE #1 OR #2
- 9) PENETRANT INSPECT PER QSI 038 4.1

RELEASED
2013-11-23

20151218 SH 1400000

DESIGN	RF	EAGLE COPTERS LTD. CALGARY, ALBERTA, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	E4715	SHEET 2 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	STUD	NTS
DATE	12.08.29	COPYRIGHT © 2012 BY EAGLE COPTERS LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM EAGLE COPTERS LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO31650**

Purchase Order Date 3/10/2016

PO Print Date 3/15/2016

Page Number 5 of 5

Order From :
SKYSERVICE
6120 MIDFIELD ROAD
MISSISSAUGA, ONTARIO L5P 1B1
CANADA

VC-SKY001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 905-678-5636

Ship To Contact

Ship To Phone

Ship Via: Delivered

Ship Acct:

Buyer

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB FCA - (Free Carrier)

Line Total: \$0.00

12 140000

E4715-3 STUD ✓

3/11/2016

Yes

3/11/2016

11.00

\$0.00

\$0.00

LIQUID PENETRANT INSPECTION AS PER QSI 038 OR
LPI AS PER ASTM 1417 LEVEL 2

Line Total: \$0.00

PO Total: \$0.00

Spoke 03-15

CL

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 3

Change Date: 3/15/2016

skyservice Work Order Traveler

Sky Service F.B.O. Inc.

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO27600	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: 31650
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON FORTY - EIGHT STUDS AS PER PO : 31650

ELEVEN STUDS , ITEM ID : E4715-3 , W/O ID : 140000

THIRTY - SEVEN STUDS , ITEM ID : E4715-1 , W/O : 140001

SP/6-03-15.

Action Taken:	Date:	Initial/Stamp:
LIQUID PENETRANT INSPECTION CARRIED OUT AS PER ASTM E-1417M-13 NO CRACK FOUND PEN.(ZL-37 , B#MPO13139), DEV.(SKD-S2,B#MPO11715) , EMU.(ZR-10B,B#MPO12373 DAS 38 9-89 MAR 15 2016	MAR 11 2016	<i>Lu</i> DOT-APP 37 53-89

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp	Date:
Name: LUCA MARCHETTA	DOT-APP 37 53-89	MAR 11 2016